

Date: Friday, 06/07/2007 9:16:09 AM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WINDOW
Job Number : 33064	
Estimate Number : 10063	
P.O. Number :	Part Number : D2958
This Issue : 06/07/2007 S.O. No. :	Drawing Number : D2958 REV. <i>2</i> <i>E</i> <i>PCAH</i> <i>for a.c.</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : THERMOFORMING	Drawing Revision : <i>2</i> <i>E</i> <i>PCAH</i>
Previous Run : 33064	Material :
Written By : <i>LL</i>	Due Date : 13/07/2007 Qty: 20 Um: Each
Checked & Approved By : <i>LL</i>	
Comment : E 04.09.25 Done by outside contract SM Est 07.06.26 Thermoform in house DL	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
-----	-------------	------------------------



Comment: Qty.: 2.5800 sf(s)/Unit Total : 51.6000 sf(s)  
1/8" Polycast II Sheet

Batch # *104 596 103735*

*07-07-10* FOR ENG. PURPOSES ONLY

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

POSITIVE RECALL  
EFFECTIVE *07-07-10* AUTH *LL*  
RELEASED

*Make 1 only - for engineering approval*

OK TO MAKE  
20

3.0	QC2
-----	-----



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

INSPECT PARTS AS THEY COME OFF MACHINE

*07-07-10*

*(24)*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*En 07/07/10*

*(x24)*

5.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE  
Thermoform as per Dwg D2958 and Folio FTA005

Dwg. Rev. *E*  
Folio Rev. *A*

*07.07.10* *LL*

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 33064

Part Number: D2958

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.07.10 WY

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.07.10

count  
x24

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

-12 SAs

07/08/10 (12)

24

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.15

Job Completion



07-08-15

→

Date: Thursday, 6/21/2007 2:29:28 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WINDOW
Job Number : 33064	
Estimate Number : 10063	
P.O. Number :	Part Number : D2958
This Issue : 6/21/2007 S.O. No. :	Drawing Number : D2958 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 30698	Material :
Written By : <u>JD 07 06 22</u>	Due Date : 7/6/2007
Checked & Approved By : <u>JD 07 06 22</u>	Qty: 20 Um: Each
Comment : E 01.09.25 Done by outside contract SM	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: \_\_\_\_\_

Order per Dwg D2958

Supplier: -Canus

Material: 1/8" thick clear Polycast 2 sheet

Supplier should protect window with protective film

Material release note required

M-ACRYLIC 5025 B

2.0

D2958P

Window



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Window

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Trim as per Template DT8568.

2-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 6/21/2007 2:29:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW

Job Number: 33064

Part Number: D2958

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.07.09	2	MAKE 1 PART FOR Verification of new Drawing	Sh.	07.07.09				
		Positive Recall 07.07.09.	Sh.	07.07.09	1			
	2a)	Verify machined part to drawing.	Sh.	07.07.09				
	6)	TRIAL FIT NEW PART TO D2956 FRAME	Sh.	07.07.09		07.08.15	Sh H0710	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

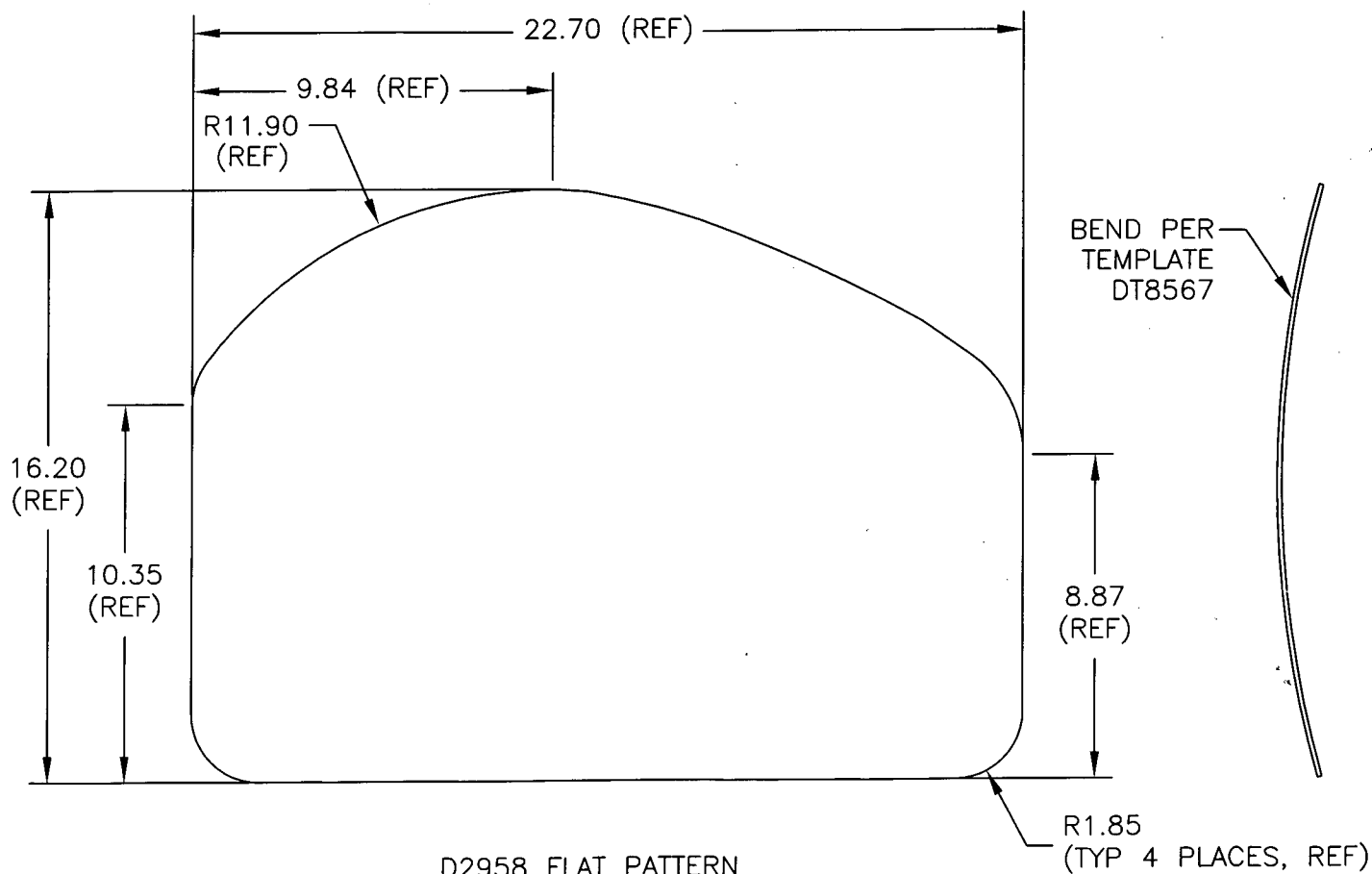
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**PRELIMINARY ISSUE**

07.07.09

DESIGN 90	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2958	REV. E SHEET 1 OF 1
DATE 07.07.06	TITLE WINDOW		SCALE 1:5
A	00.01.20	NEW ISSUE	
B	00.02.23	Ø0.156 HOLES WERE Ø0.141 (NCR 407)	
C	01.05.30	REMOVE HOLES, UNIFORMLY SMALLER	
D	06.04.13	UPDATE MATERIAL PER NCR 029	
E	07.07.06	REDESIGN PER PAR 188	



D2958 WINDOW

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) ROUTER PER TEMPLATE DT8568
- 3) BEND PER TEMPLATE DT8567
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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